

Ship Friday!

Rev B 5/13/15

~~ELIMINATED ISSUE~~

Work Order ID 109180

109180

November-13-13 10:04:08 AM

Item ID: D4769-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Wearplate Assembly
Start Date: 11/13/13 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 11/15/13 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4769	PBS <u>Rev B</u>								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120		0.00							
120									
Large Fab	Memo	0.00							
Large Fab	1- Weld hardcoat on bars as per dwg A/R 2059b hardcoat Batch#: <u>M126273</u>								
	2- Weld bar to wearplate as per dwg A/R s.s. rod Batch #: <u>M126048</u>								
	3- Weld shim as per dwg A/R s.s. rod Batch #: <u>M126048</u>								
	4- Transfer drill drain holes as per dwg								

1 13-11-14 MAL

1 13-11-14 MAL

Work Order ID 109180

November-13-13 10:04:08 AM

109180

Page 3

Item ID: D4769-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Assembly

Start Date: 11/13/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/15/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 DAS 27 9-89 151115							1 inspect as per Dwg PBS
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: Memo	0.00 0.00							1x DAS 28 9-89 13-11-15
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							13/11/18 Release as per Dwg Rev B

u 13-11-15

POSITIVE RECALL

EFFECTIVE 13-11-13 AUTH lu
RELEASED 8 DATE 13/11/15

Rev B

Picklist Print

November-13-13 10:04:08 AM

Page 1

Work Order ID: 109180
 Parent Item: D4769-041
 Parent Item Name: Wearplate Assembly

Start Date: 11/13/13 Required Date: 11/15/13
 Start Qty: 1.00 Required Qty: 1.00

Comments: IPP REV:A 13.03.27 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4769-1 Wearplate		Manufactured	No				Each	4.0000		1			
----------------------	--	--------------	----	--	--	--	------	--------	--	---	--	--	--

~~B 109182 X1~~

Location	Loc Qty	Loc Code
prelim	1	
106621	1	
WA001	3	
105709	2	
106576	1	

13-11-14 MAL

D4769-3 Wearplate Shim		Manufactured	No				Each	3.0000		1			
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Location	Loc Qty	Loc Code
prelim	2	
105902	1	
106623	1	
WA001	1	
106583	1	

13-11-14 MAL

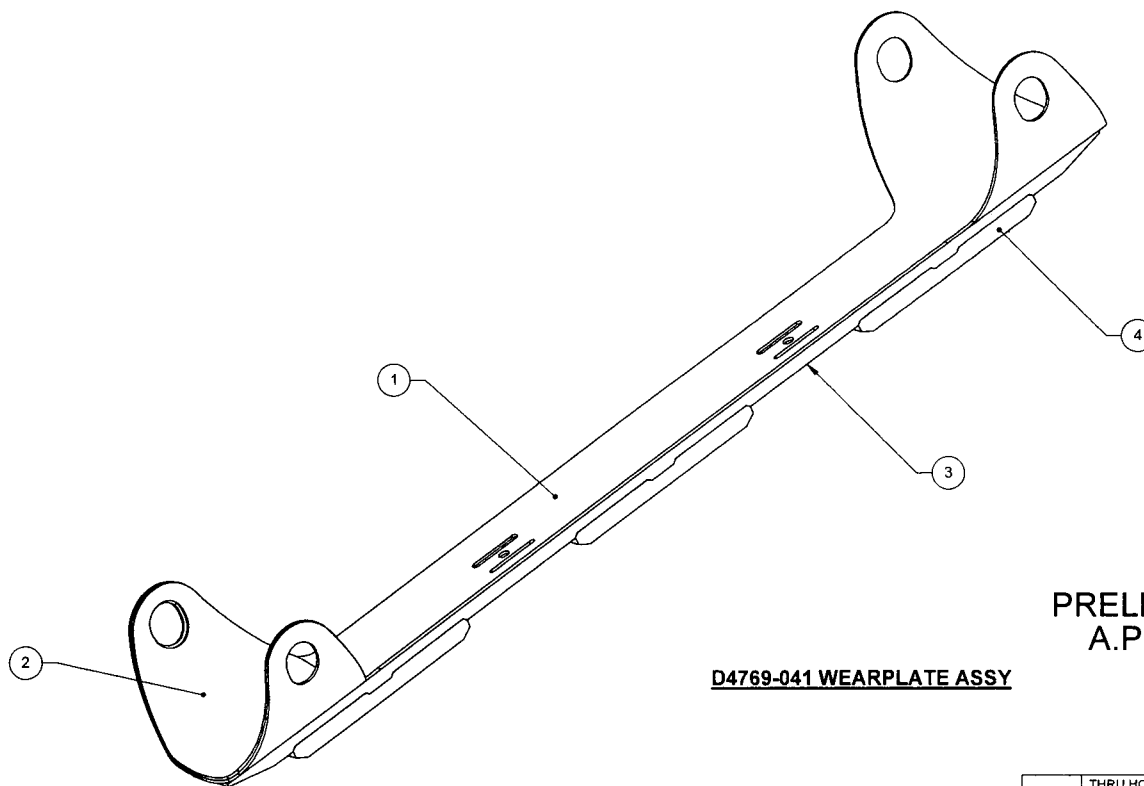
D4770-1 Bar		Manufactured	No				Each	6.0000		2			
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~~B 109190 X2~~

Location	Loc Qty	Loc Code
WA001	6	
105710	2	
106047	4	

13-11-14 MAL

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4769-041	WEARPLATE ASSY
1	1	D4769-1	WEARPLATE
2	1	D4769-3	WEARPLATE SHIM
3	2	D4770-1	BAR
4	A/R	2059B	HARDCOAT WELD

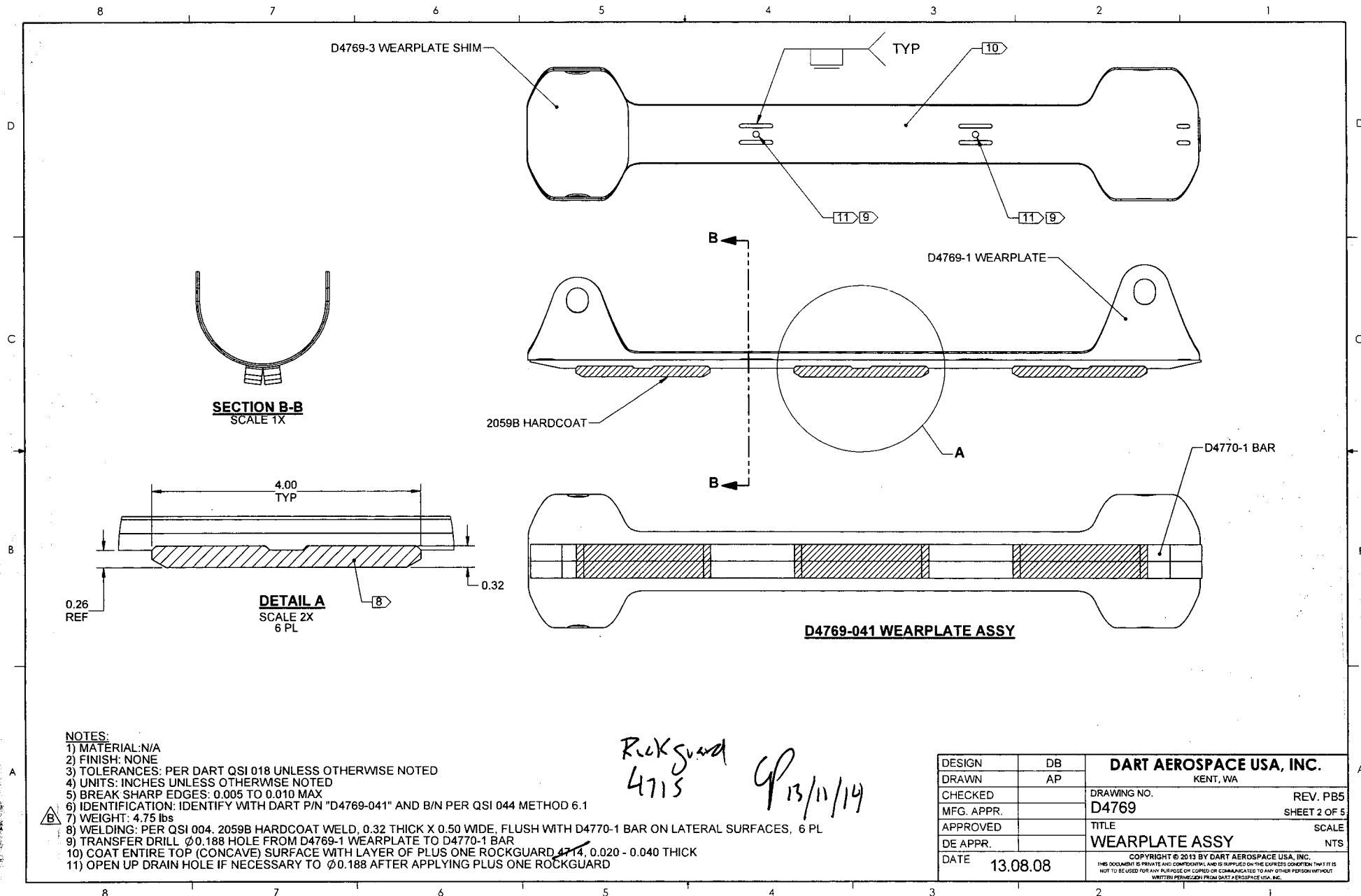


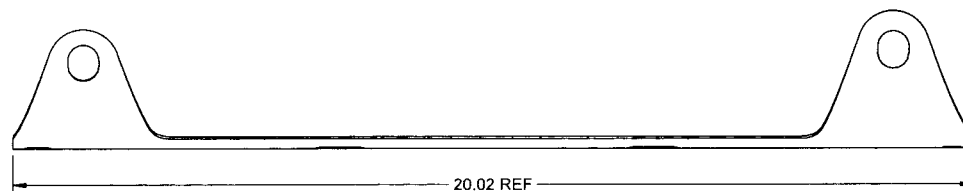
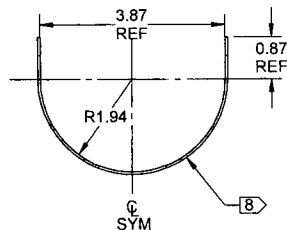
D4769-041 WEARPLATE ASSY

PRELIMINARY PB5
A.P. (13.09.11)

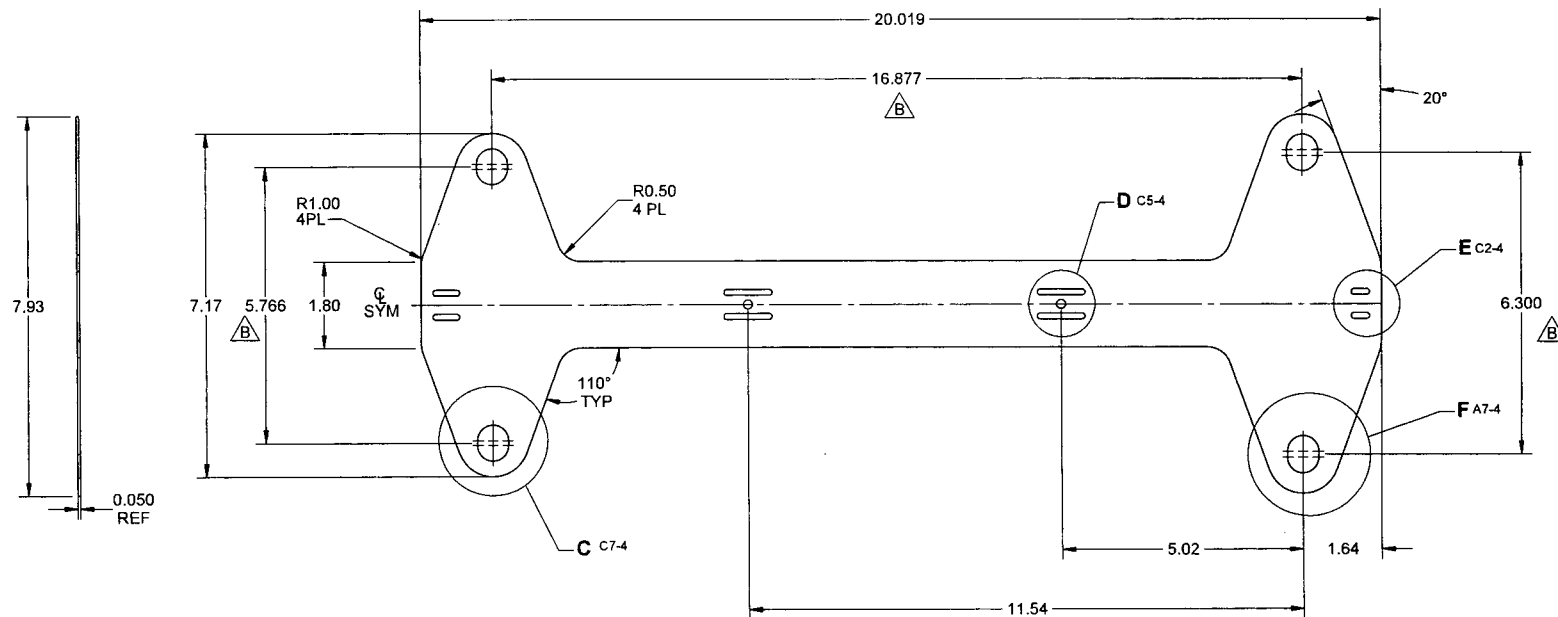
w/o 109180

PB5	THRU HOLES NOW SLOTS. VARIOUS DIMENSIONAL CHANGES. UPDATED PART WEIGHTS. REMOVED GRAIN DIRECTION (B5-3). D4769-3 WAS D4682-8. ADDED D4769-3 SHIT 3	AP	13.08.08
A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED		DRAWING NO.	REV. PB5
MFG. APPR.		D4769	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	13.08.08	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	





D4769-1 WEARPLATE
(MAKE FROM D4769-1F)

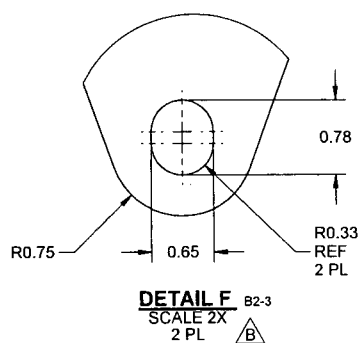
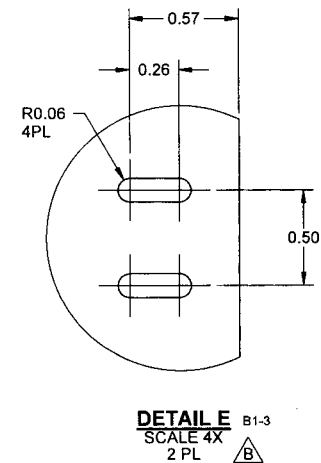
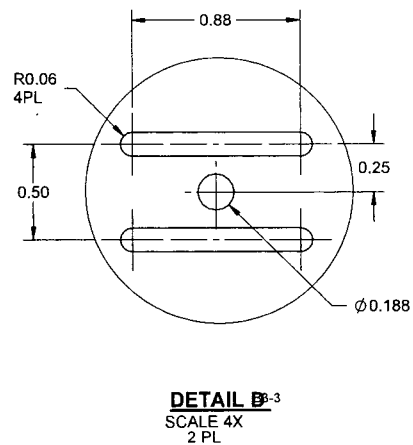
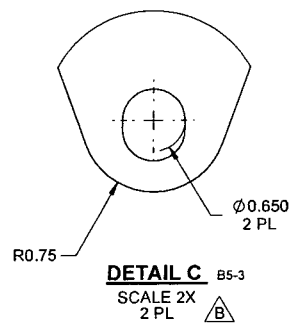


D4769-1F WEARPLATE
(FLAT PATTERN)

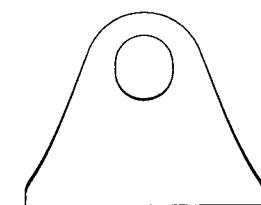
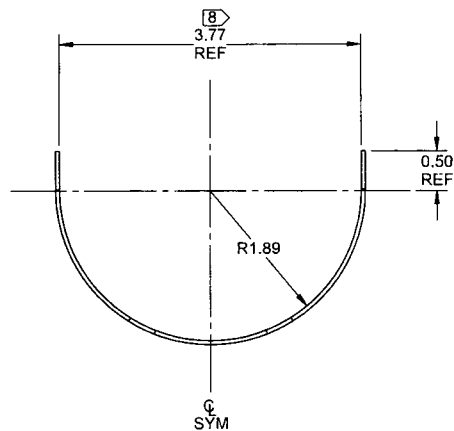
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK (REF DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.83 lbs
- 8) IT IS ACCEPTABLE TO OVERBEND D4769-1 UP TO 2 DEG OR UNDERBEND UP TO 5 DEG

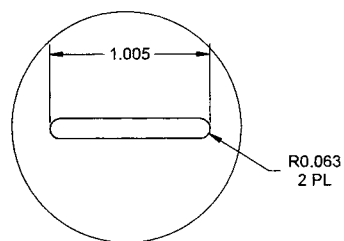
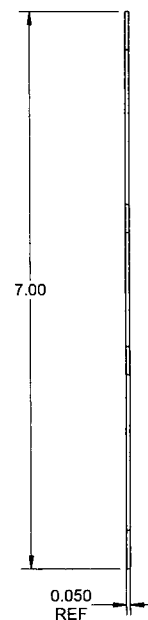
DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4769	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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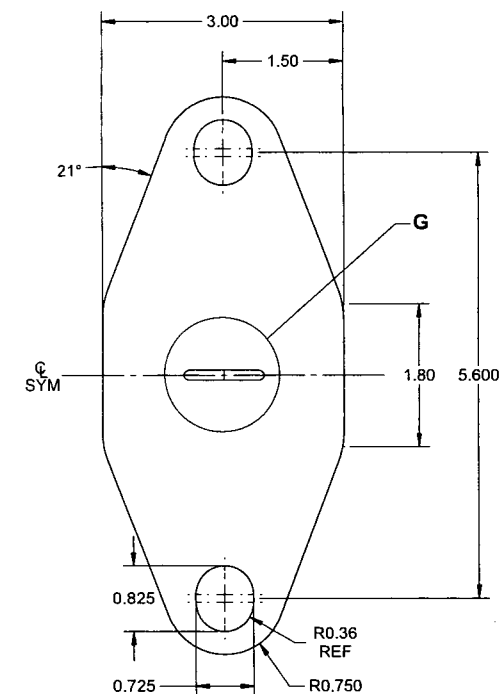
DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED		DRAWING NO.	REV. PB5
MFG. APPR.		D4769	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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D4769-3 WEARPLATE SHIM
(MAKE FROM D4769-3F)



DETAIL G
SCALE 2X



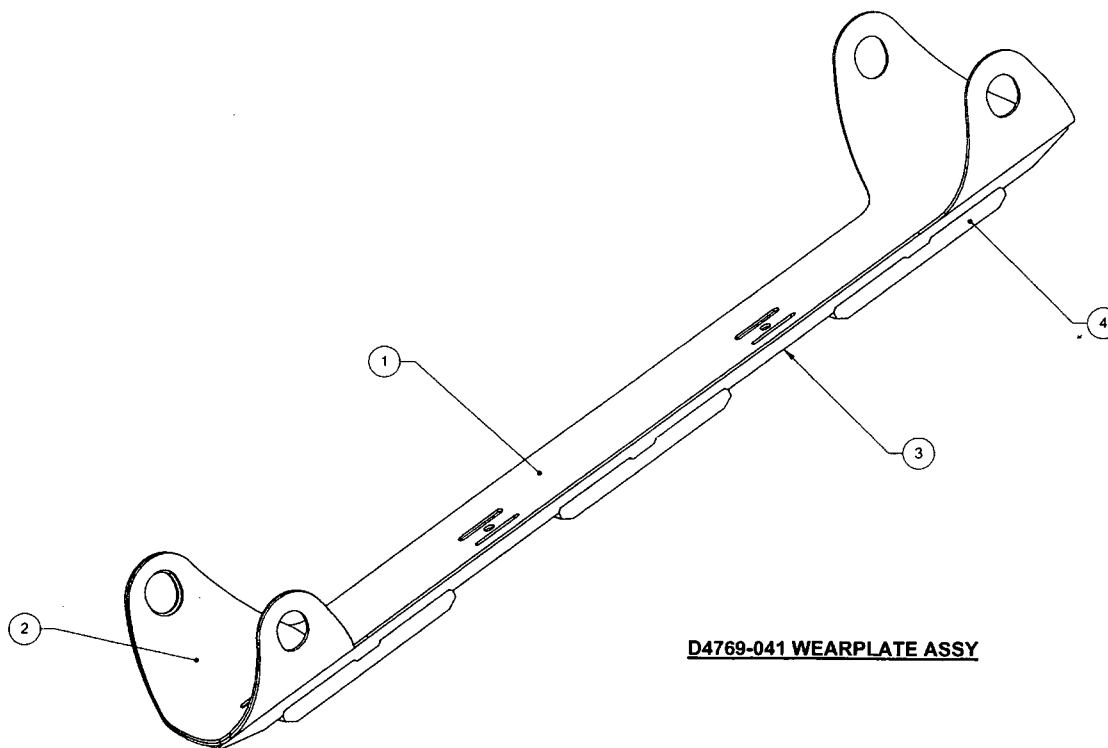
D4769-3F WEARPLATE SHIM
(FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK (REF DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.21 lbs
- 8) IT IS ACCEPTABLE TO OVERBEND D4769-3 UP TO 2 DEG OR UNDERBEND UP TO 5 DEG

DESIGN	AP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED		DRAWING NO.	REV. PB5
MFG. APPR.		D4769	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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ITEM	QTY	P/N	DESCRIPTION
	X	D4769-041	WEARPLATE ASSY
1	1	D4769-1	WEARPLATE
2	1	D4769-3	WEARPLATE SHIM
3	2	D4770-1	BAR
4	A/R	2059B	HARDCOAT WELD



D4769-041 WEARPLATE ASSY

RELEASED
2013-11-13
MD

REV. B	THRU HOLES NOW SLOTS, VARIOUS DIMENSIONAL CHANGES, UPADATED PART WEIGHTS, REMOVED GRAIN DIRECTION, D4769-3 WAS D4682-9, ADDED D4769-3 SHT 5.	AP	13.09.10
REV. A	NEW ISSUE	AP	13.02.13
DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	DA	D4769	SHEET 1 OF 5
APPROVED	DA	TITLE	SCALE
DE APPR.	DA	WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1

D

C

B

A

D4769-3 WEARPLATE SHIM

TYP

10

11 9

11 9

SECTION B-B

2059B HARDCOAT

D4769-1 WEARPLATE

A

D4770-1 BAR

B

B

0.26
REF

DETAIL A
SCALE 2X
6 PL

4.00
TYP

0.32

D4769-041 WEARPLATE ASSY

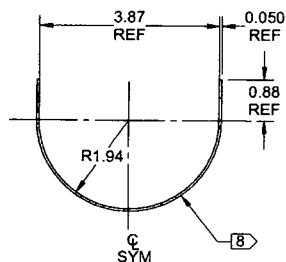
RELEASED
2013-11-13
WJ

NOTES:

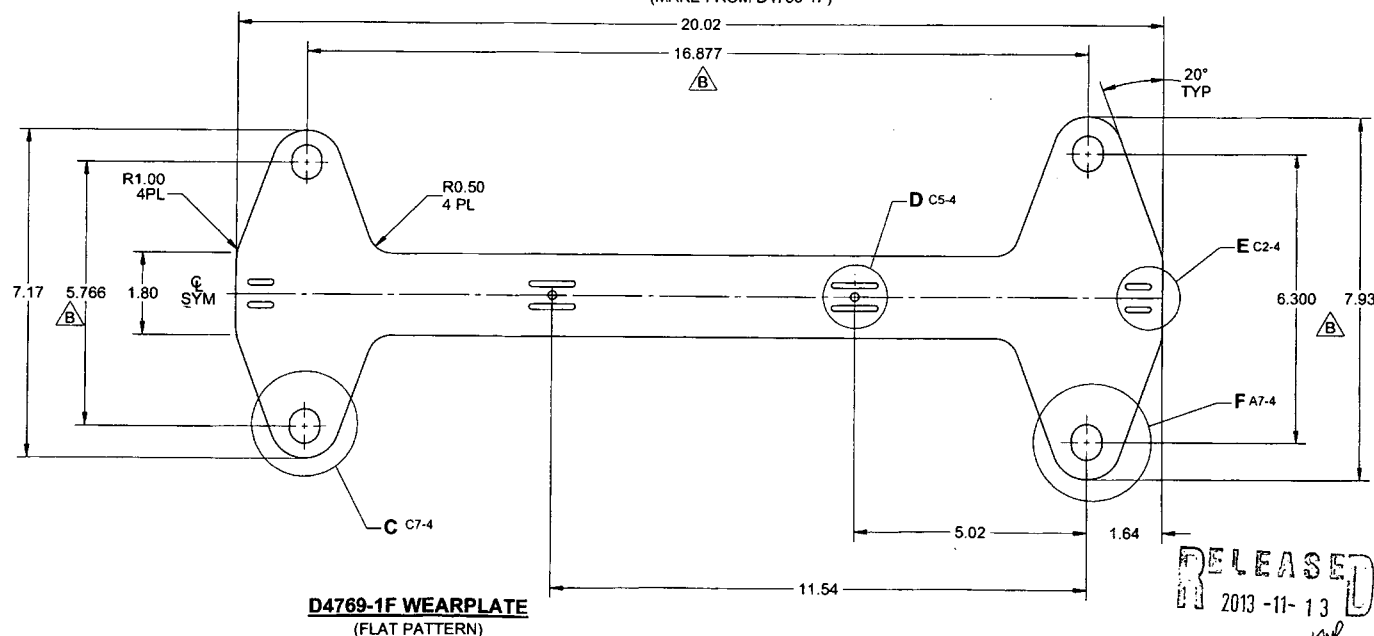
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4769-041" AND B/N PER QSI 044 METHOD 6.1
- 7) WEIGHT: 3.27 lbs
- 8) WELDING: PER QSI 004. 2059B HARDCOAT WELD, 0.32 THICK X 0.50 WIDE, FLUSH WITH D4770-1 BAR ON LATERAL SURFACES, 6 PL
- 9) TRANSFER DRILL $\phi 0.188$ HOLE FROM D4769-1 WEARPLATE TO D4770-1 BAR
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH LAYER OF PLUS ONE ROCKGUARD 4714, 0.020 - 0.040 THICK
- 11) OPEN UP DRAIN HOLE IF NECESSARY TO $\phi 0.188$ AFTER APPLYING PLUS ONE ROCKGUARD

DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	DS	D4769	SHEET 2 OF 5
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1



D4769-1 WEARPLATE
(MAKE FROM D4769-1F)



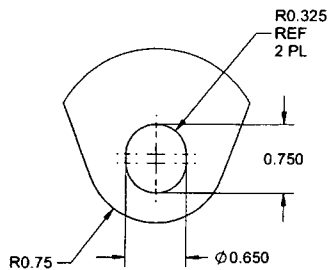
D4769-1F WEARPLATE
(FLAT PATTERN)

NOTES:

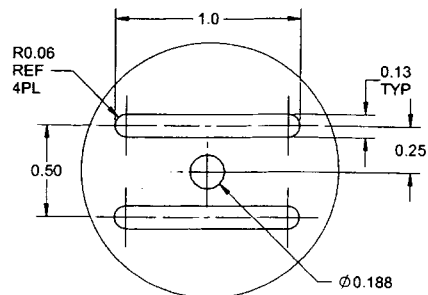
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- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.83 lbs
- 8) IT IS ACCEPTABLE TO OVERBEND D4769-1 UP TO 2 DEG OR UNDERBEND UP TO 5 DEG

DESIGN	DB	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	AS	D4769	SHEET 3 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	WEARPLATE ASSY	NTS
DATE	13.09.10	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

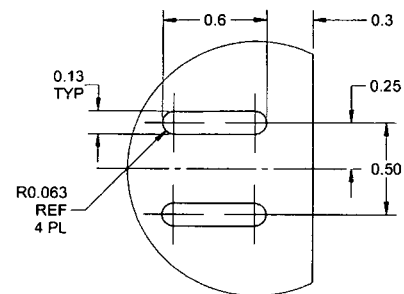
RELEASED
2013-11-13



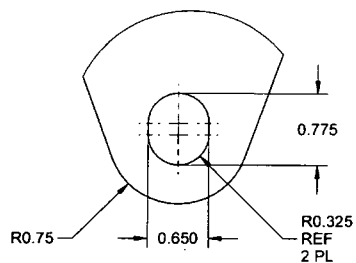
DETAIL C B5-3
SCALE 2X
2 PL $\triangle B$



DETAIL D B3-3
SCALE 4X
2 PL



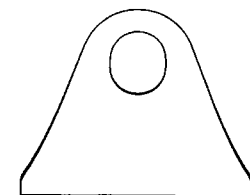
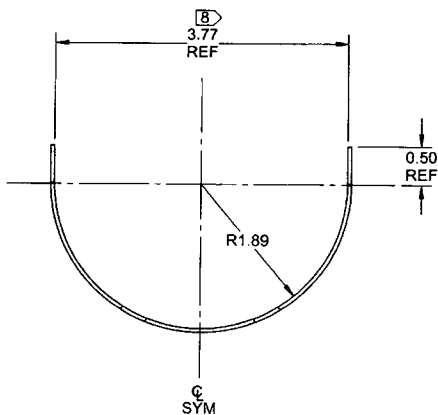
DETAIL E B1-3
SCALE 4X
2 PL $\triangle B$



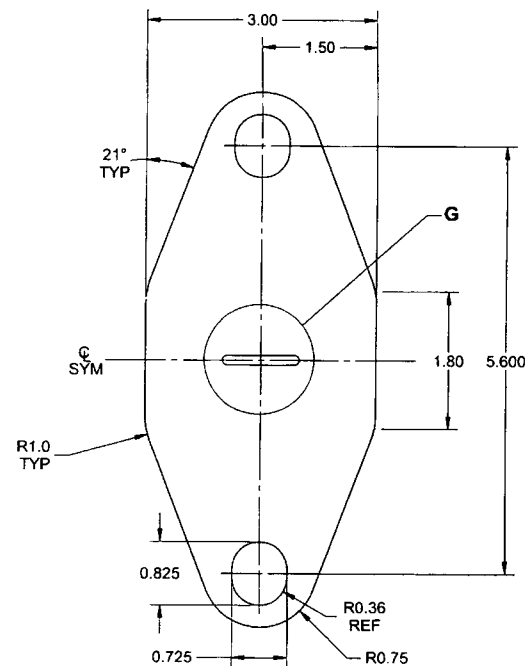
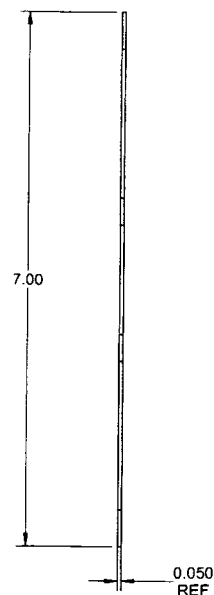
DETAIL F B2-3
SCALE 2X
2 PL $\triangle B$

RELEASED
2013-11-13

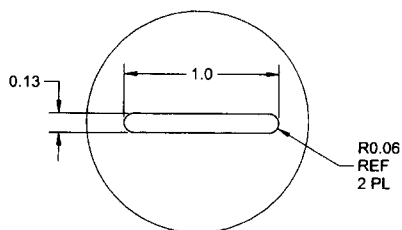
DESIGN	DB	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	ASS	DRAWING NO. D4769	REV. B SHEET 4 OF 5
MFG. APPR.	DB	TITLE WEARPLATE ASSY	SCALE NTS
APPROVED	DB	<small>COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DE APPR.	DB		
DATE	13.09.10		



D4769-3 WEARPLATE SHIM
(MAKE FROM D4769-3F)



D4769-3F WEARPLATE SHIM
(FLAT PATTERN)



DETAIL G
SCALE 2X

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK (REF DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.21 lbs
- 8) IT IS ACCEPTABLE TO OVERBEND D4769-3 UP TO 2 DEG OR UNDERBEND UP TO 5 DEG

DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	<i>AS</i>	DRAWING NO. D4769	REV. B SHEET 5 OF 5
MFG. APPR.	<i>AS</i>	TITLE WEARPLATE ASSY	SCALE NTS
APPROVED	<i>AS</i>	<small>COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DE APPR.	<i>AS</i>		
DATE	13.09.10		

RELEASE
2013-11-13